

Spl-1

Work Order ID 105568 -1

105568

Page 1

August-08-13 8:58:58 AM

Item ID: D3017-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 8/08/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/08/13 Req'd Qty: 12.00

12

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLS

Date: 13-08-08

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3017	Rev B
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100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3017

Dwg Rev: B

Prog Rev: B

2-Deburr

24 0 13.08.13

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

24 0

Work Order ID 105568

August-08-13 8:58:58 AM

105568

Page 2

Item ID: D3017-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lug
Start Date: 8/08/13 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 8/08/13 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00 S 8/2/13 B. 8. 13				24 can			
130 *130* Brake NC Brake NC	NC BRAKE Memo 1-Deburr 2-Form as per Dwg D3017 using DT9835	0.00 0.00				1			P. 3/08/14
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 DAS 16 8/3/08/13				(71)			

Work Order ID 105568

105568

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August-08-13 8:58:58 AM

Item ID: D3017-7

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 8/08/13

Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/08/13

Req'd Qty: 12.00

12

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours
0.00

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

150

150

Packaging

Packaging

Packaging

Memo

0.00

Identify and bag with light oil (Vactra oil #2), then Stock
Location: w/lt oil

1 Q 13-8-14

160

160

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MLS 13-8-15

PL 13.8.14

Split 1

Picklist Print

Page 1

August-08-13 8:58:57 AM

Work Order ID: 105568

Parent Item: D3017-7

Parent Item Name: Lug

Start Date: 8/08/13

Required Date: 8/08/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B03.05.09ReformatKJ/RF
IPP Rev:C 08-04-11 now made on water jet DD verified by:EC
revB DD verified by:JLM

IPP RevB: as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NS.049 4130 Sheet .049		Purchased	No			100	sf	124.1903	0.102	1.2884208			13.08.13

Location

Loc Qty

Loc Code

MAT020

124.190263

11612

4.2

123049

17.340263

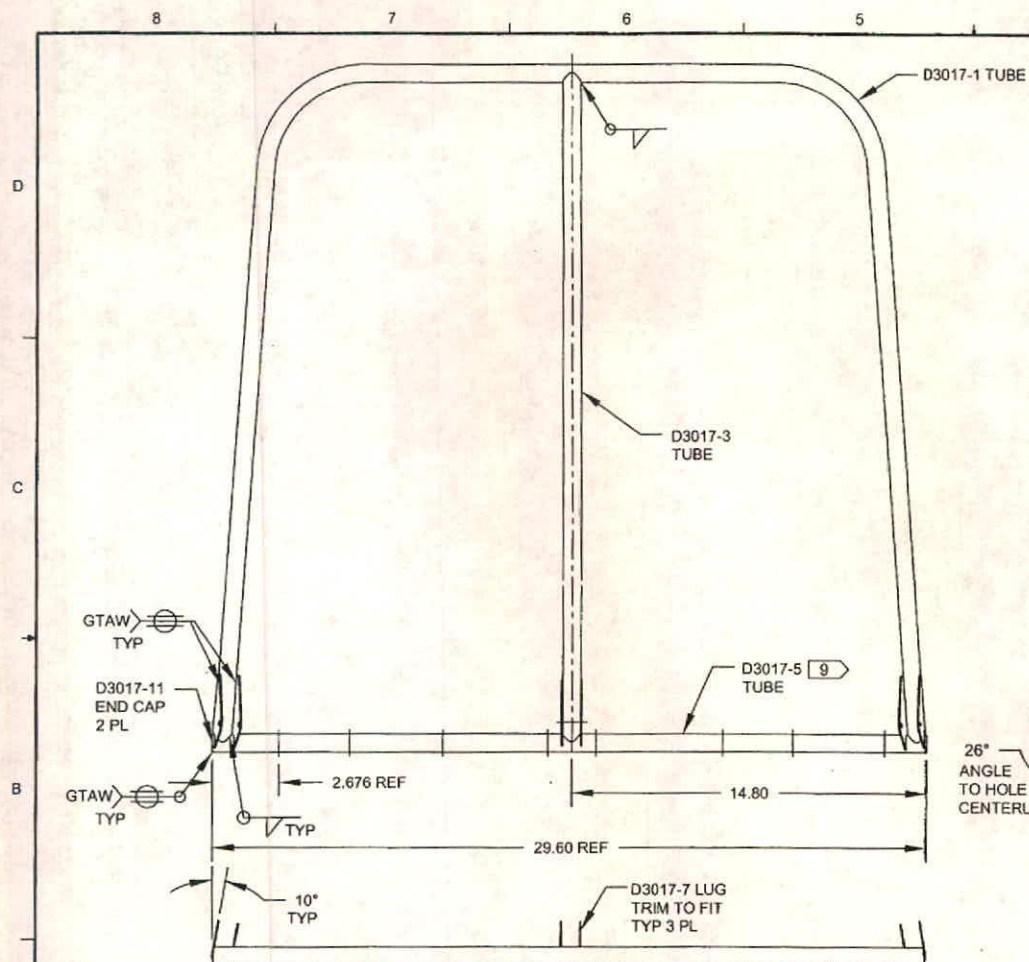
124283

102.65

Shp
13.8.13



124283 → 2.6



ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL

105568 MLJ
13-08-08

RELEASED
2010-02-02
WJP

D3017-041 BACK FRAME ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

B	REFORMAT DWG, -5 TUBE WALL THKNS REV'D (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

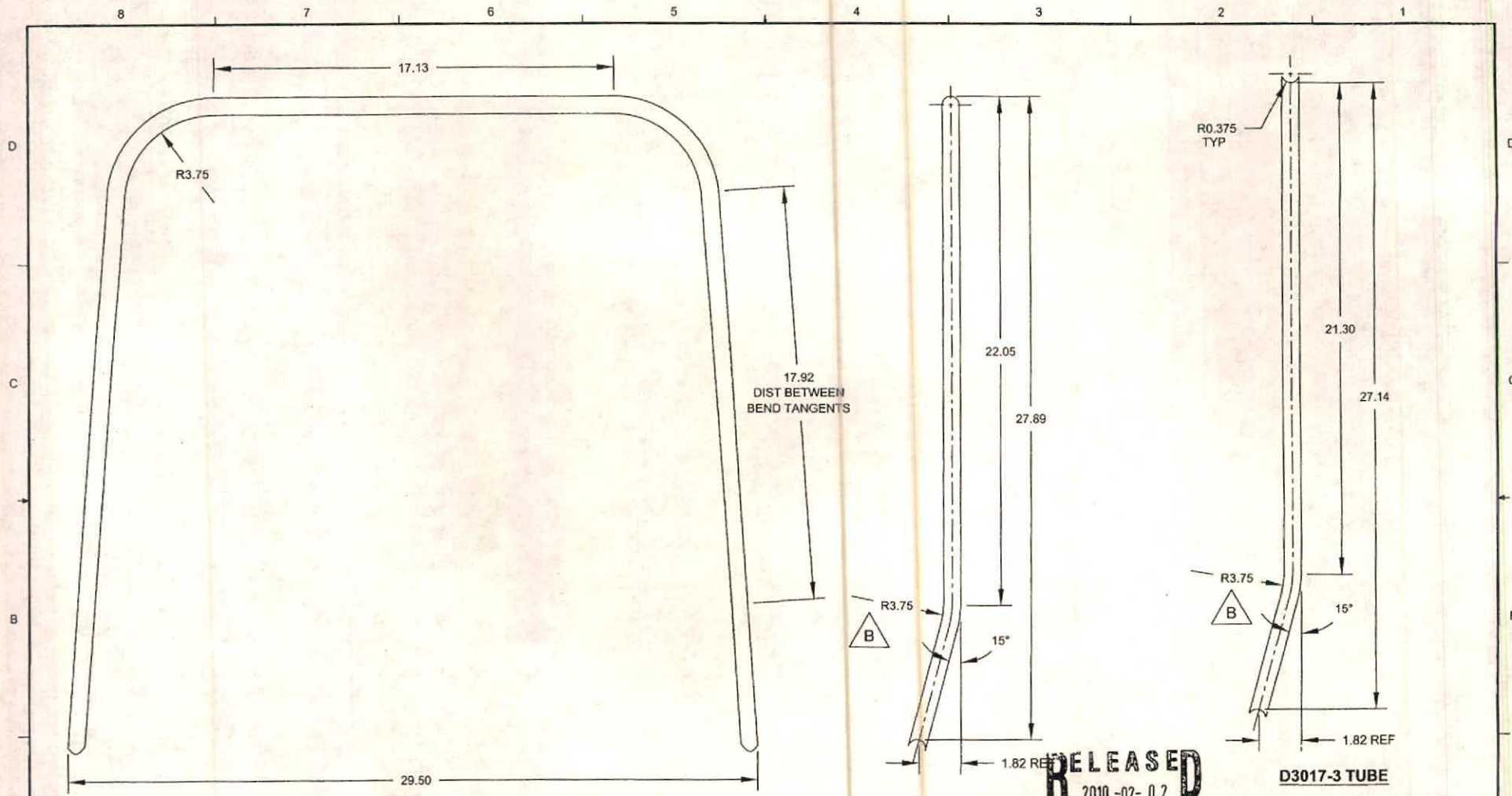
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3017 REV. B
SHEET 1 OF 4

TITLE BACK FRAME ASSEMBLY SCALE NTS

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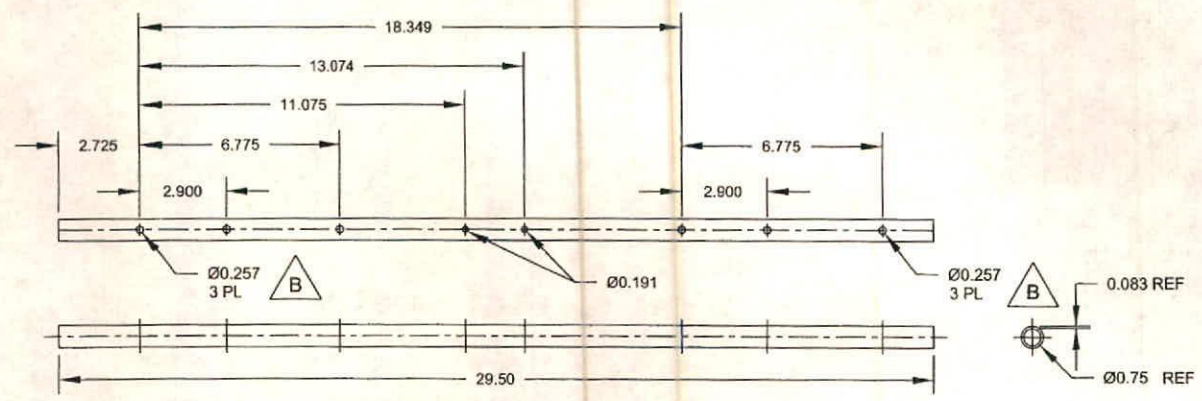


- NOTES:
- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D3017-1: 2.38 lbs; D3017-3: 0.84 lbs.

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2010-02-02
JWP

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D3017-5 TUBE

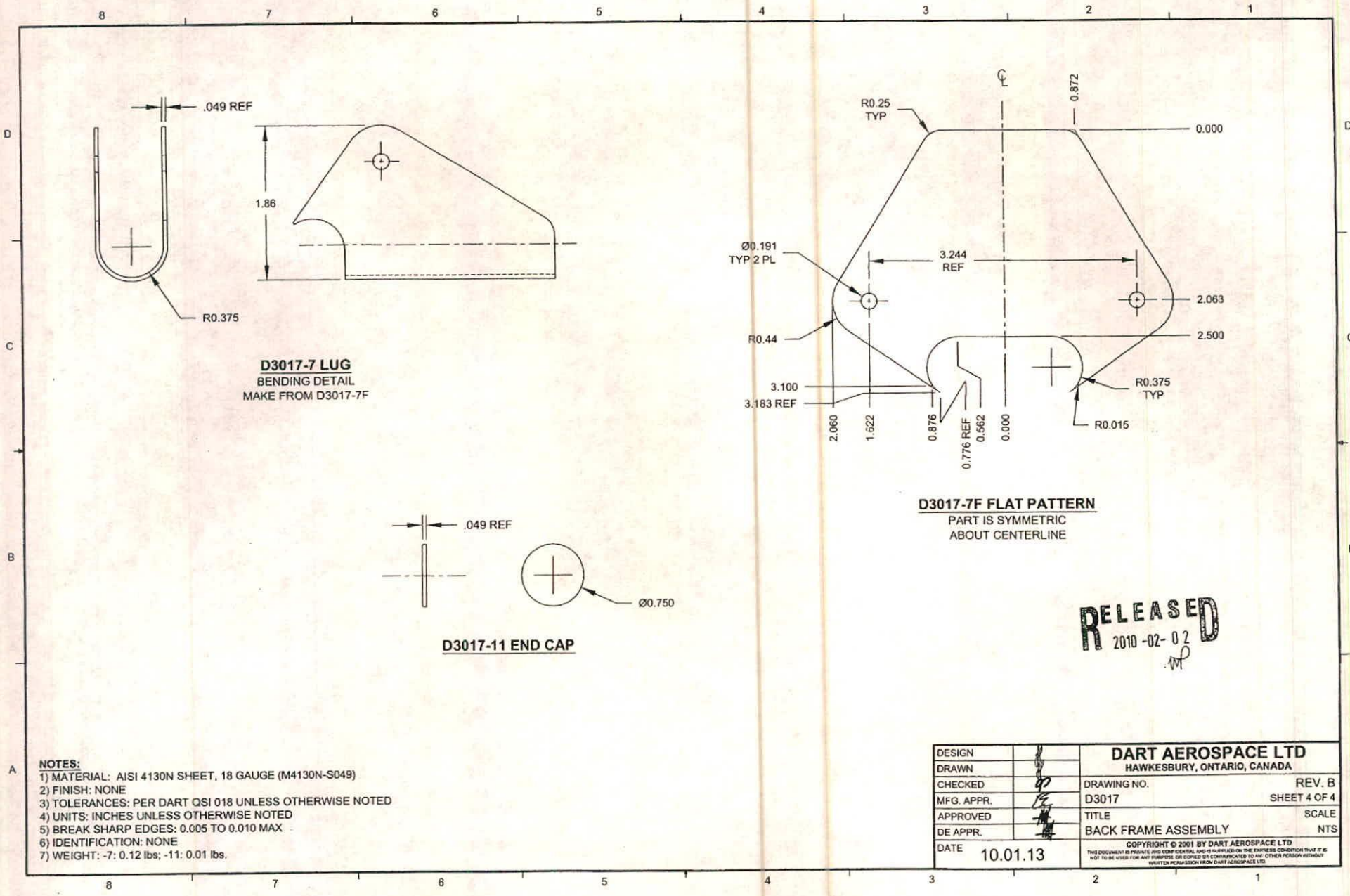
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2010-02-02
MP

- NOTES:**
- 1) MATERIAL: AISI 4130N TUBE, $\varnothing 0.75$ DIA x 0.083 WALL (M4130N-T0750W083)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.89 lbs

B

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